

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001216**Date Inspected:** 14-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** West Deviation Saddle Segment W2E2**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QAI) representative, Mr. Wai Pau traveled to Nikko Inspection Service (NIS) office, to review radiographic testing (RT) film result of ASME IX Shielded Metal Arc Welding (SMAW) horizontal position (2G) and vertical position (3G) welder qualification tests. A total of twelve films for 2G and eleven films for 3G welder qualification films submitted to Caltrans QAI for reviewing. The source of radiation for films used is portable X-ray model Radioflex-300EGM made by Rigaku Denki Service and performed by NIS radiographer Level II Mr. Osamu Nitami on Jan-9-2008. The radiograph film used is type Fuji #80, size 114mm x 432mm with wire type Image Quality Indicators (IQI) ASTM 1B. The twenty-three films also evaluated and accepted by NIS interpreter Level II Mr. Masanobu Nakajima prior Caltrans QAI reviewing. Based on Caltrans QA reviewing, the twenty-three radiograph films quality standard and weldments quality standard results in the films appeared to be in general compliance with requirements of the Caltrans Special Provisions and ASME IX 2006. Twenty-three Caltrans Lot# B88-012-08 to B88-034-08 were assigned on those films for tracking propose.

Summary of Conversations:

No relevant conversations took place on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer (858)697-6363, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Brasel, Ron	QA Reviewer
